

**Work Order ID 58973**

Thursday, May 20, 2010 12:37:26 PM



Page 1

Item ID: D3805-7

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 5/20/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

*H*Date: 10-5-20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

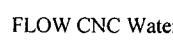
Draw Nbr

Revision Nbr

D3805

Rev A

100

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

*R 10-6-9*

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

*R 10-6-10*

Memo

1-Cut as per Dwg D3805

Dwg Rev: AProg Rev: A

2-Deburr if necessary

*2*

304 .050

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

S. W. L. 109

(42)

130



Brake NC

Brake NC

Memo

0.00

0.00

SB 10/06/16

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. W. L. 106

(42)



W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150

Operation  
DescriptionIdentify as per dwg & Stock Location: W/S

Packaging

Packaging

160



QC

Quality Control

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

PL10-6-22(2)10/06/23PL 10-6-22(2)

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Thursday, May 20, 2010 12:37:31 PM

Page 1

Work Order ID: 58973



Parent Item: D3805-7



Parent Item Name: Plate

Start Date: 5/20/2010

Required Date: 5/31/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S18GA 		Purchased		No		100	sf	140.0179	2.091			HB 10-6-9

304/316 .050 Sheet

Location	Loc Qty	Loc Code
MAT20	140.0179	
108156	1.7	
111743	10.1	
112885	32.2179	12885
113062	96	

(2)

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DART AEROSPACE LTD	Work Order:	58973
Description: Wearplate	Part Number:	D3805-7
Inspection Dwg: D3805	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>BB</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 10-6-9	Date: 10/06/09	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
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8

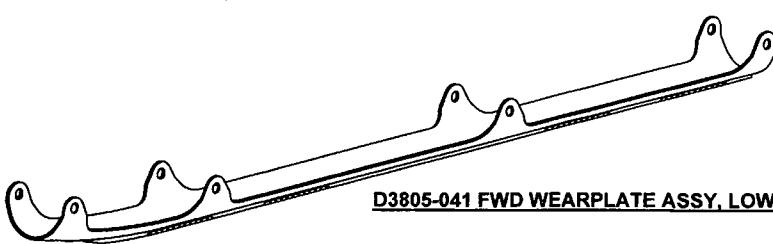
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5

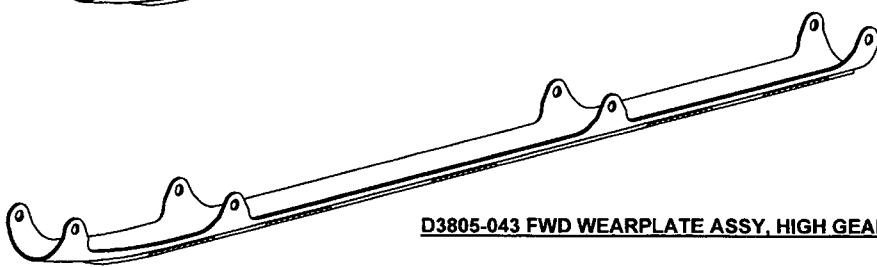
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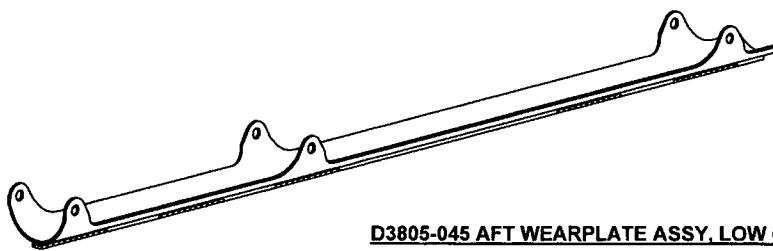
D3805-041 FWD WEARPLATE ASSY, LOW GEAR

C



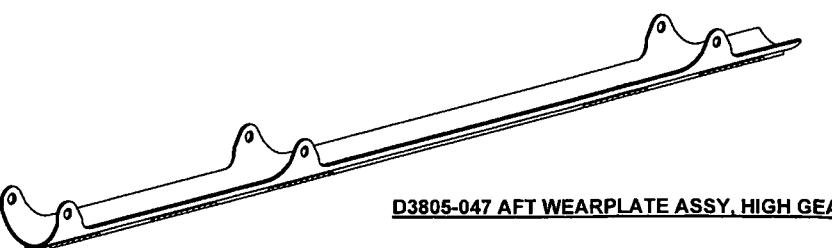
D3805-043 FWD WEARPLATE ASSY, HIGH GEAR

B



D3805-045 AFT WEARPLATE ASSY, LOW GEAR

A



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY  
RETURN TO  
ENGINEERING.

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 58923

BD10-5-20

RELEASED

GP 09-03-03

Per ECN 09-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	IP		
DRAWN			
CHECKED	AS		
MFG. APPR.	NA		
APPROVED	NA		
DE APPR.	NA		
DATE	08.11.21		

DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

REV. A  
SHEET 1 OF 8  
SCALE  
NTS

DRAWING NO.  
D3805  
TITLE  
WEARPLATE ASSY  
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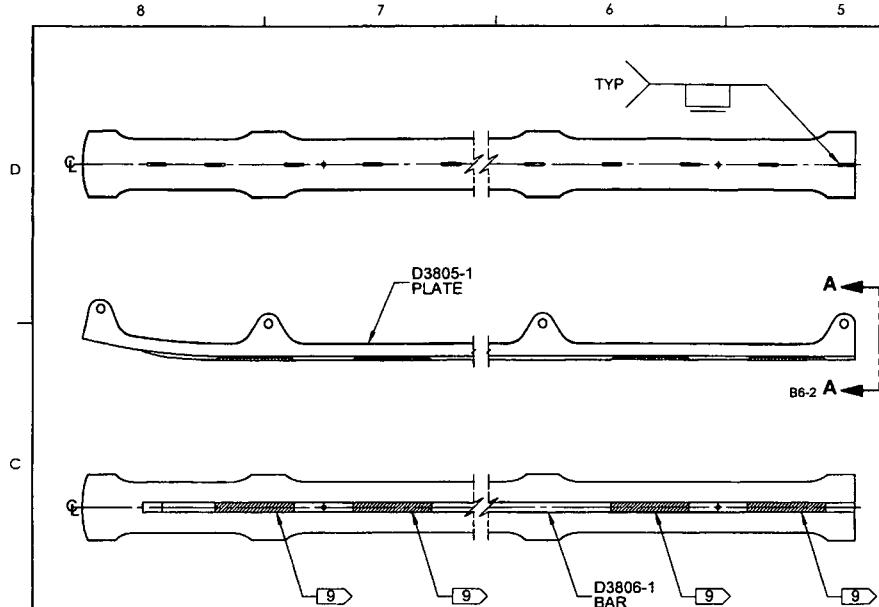
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

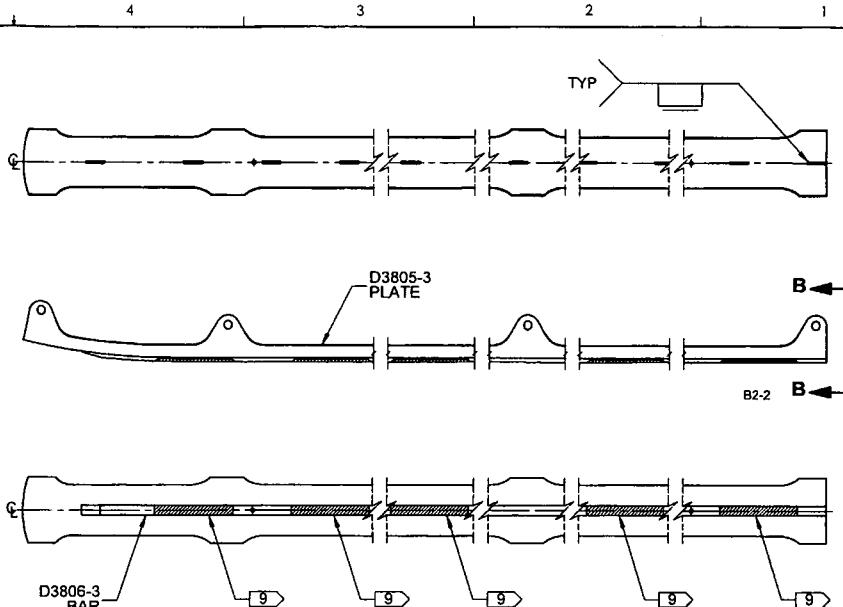
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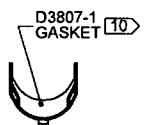
NOTE: Date & initial all entries



D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



VIEW A-A C5-2



VIEW B-B C1-2

w/0 58973

RELEASED  
(P 09.03.23)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	10	DART AEROSPACE USA, INC.
DRAWN	1	PORT HADLOCK, WA
CHECKED	AJS	DRAWING NO.
MFG. APPR.	N	REV. A
APPROVED	10	D3805
DE APPR.	10	SHEET 2 OF 8
DATE	08.11.21	TITLE
		WEARPLATE ASSY
		SCALE
		NTS
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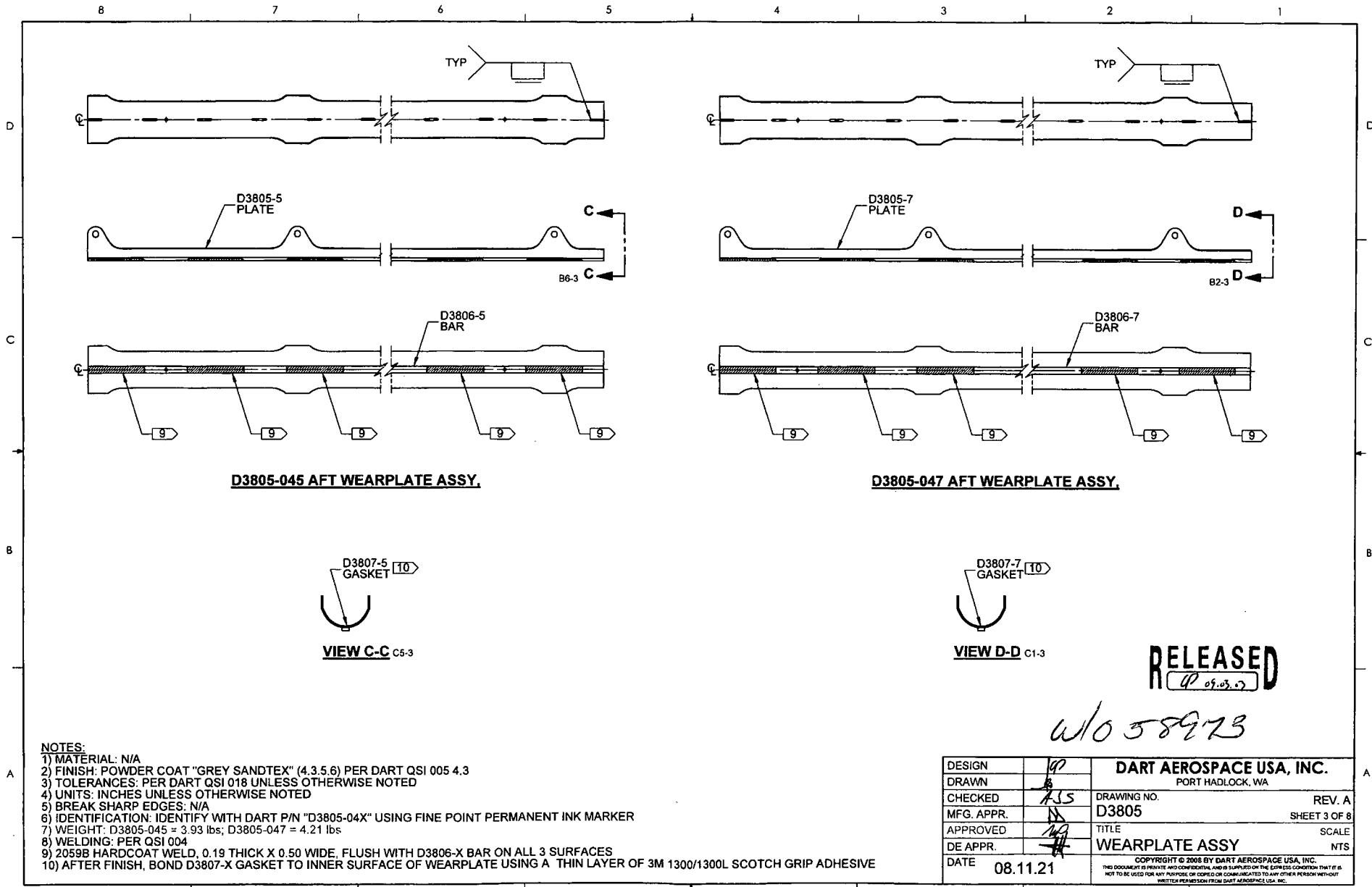
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DRAWN	5	PORT HADLOCK, WA
CHECKED	AJS	DRAWING NO.
MFG. APPR.	NA	D3805
APPROVED	NA	REV. A
DE APPR.	NA	SHEET 3 OF 8
DATE	08.11.21	TITLE
		WEARPLATE ASSY
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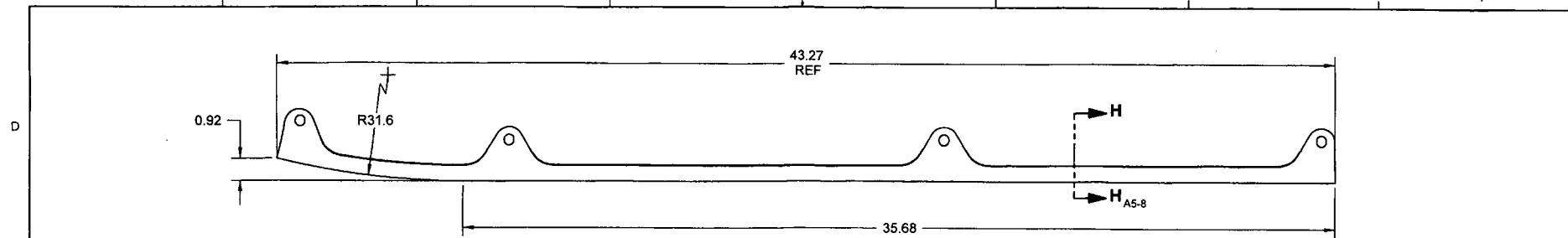
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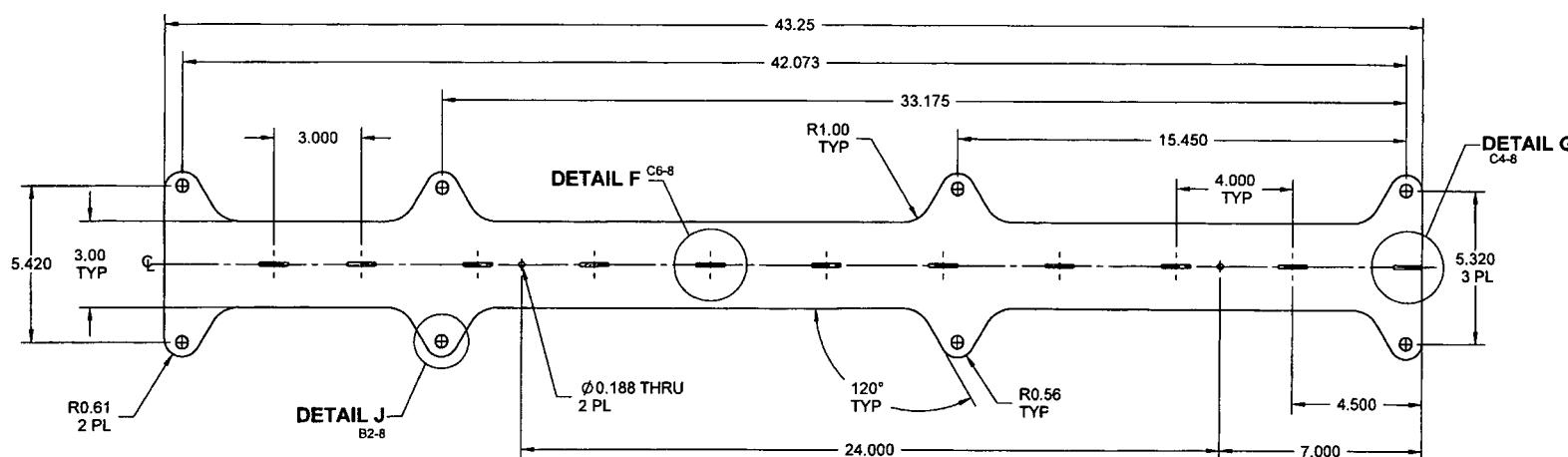
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8 7 6 5 4 3 2 1



**D3805-1 PLATE**  
(MAKE FROM D3805-1F)



wb 58923

RELEASED  
P 01-07-07

A

## NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

DESIGN	10	DART AEROSPACE USA, INC.
DRAWN	10	PORT HADLOCK, WA
CHECKED	AS	
MFG. APPR.	DN	DRAWING NO. REV. A
APPROVED	10	D3805 SHEET 4 OF 8
DE APPR.	10	TITLE SCALE
DATE	08.11.21	WEARPLATE ASSY NTS

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8 7 6 5 4 3 2 1

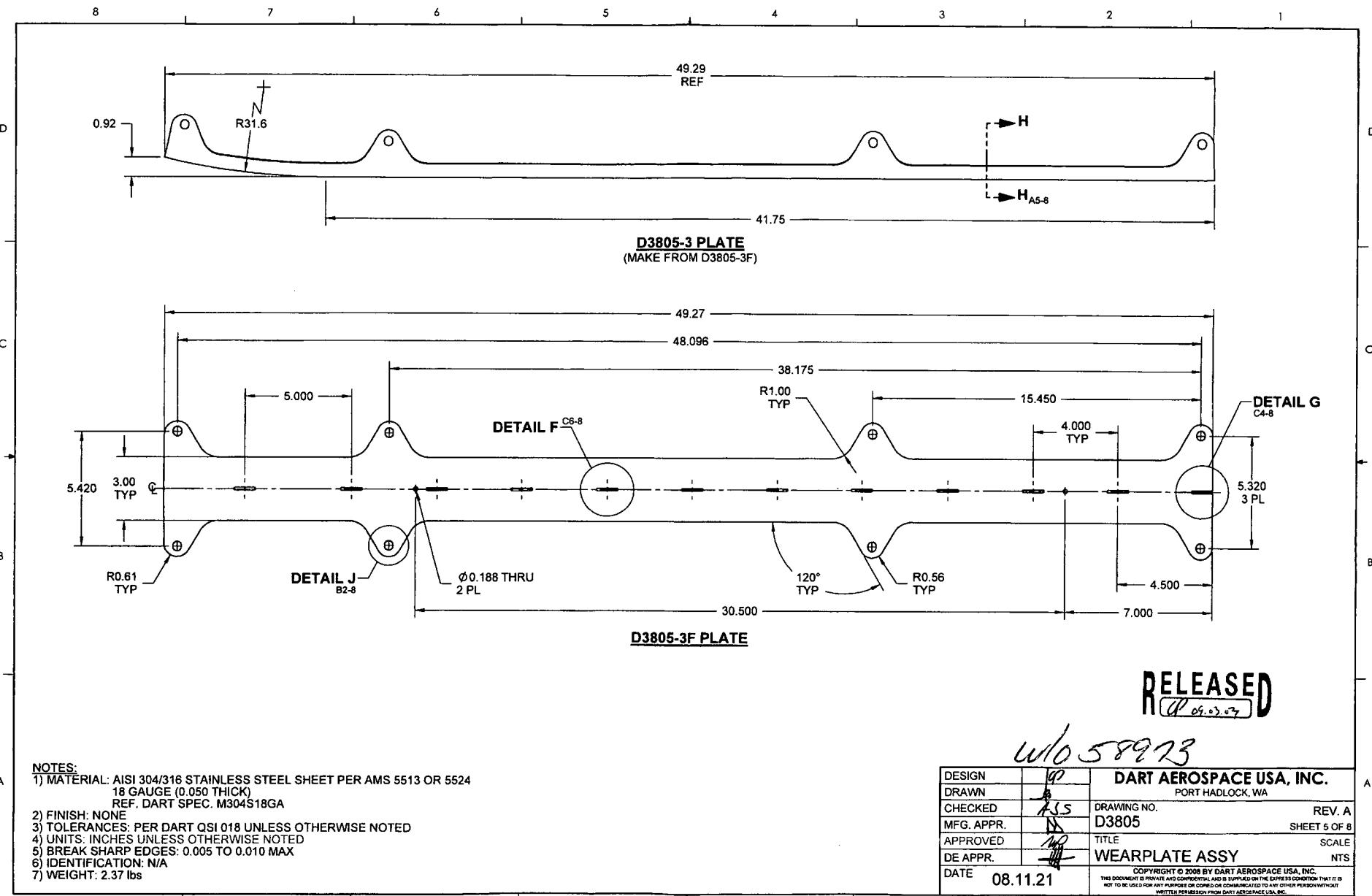
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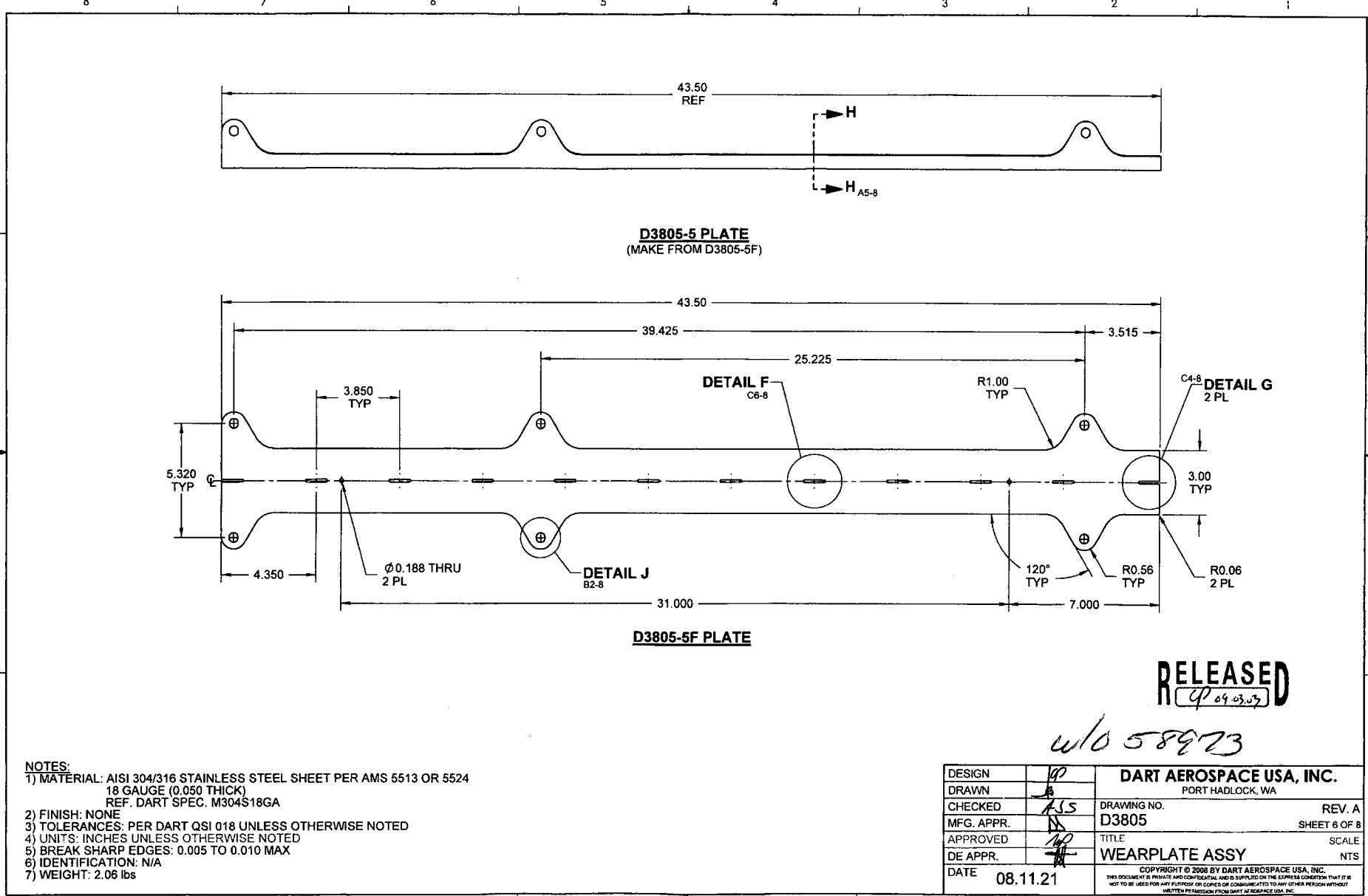
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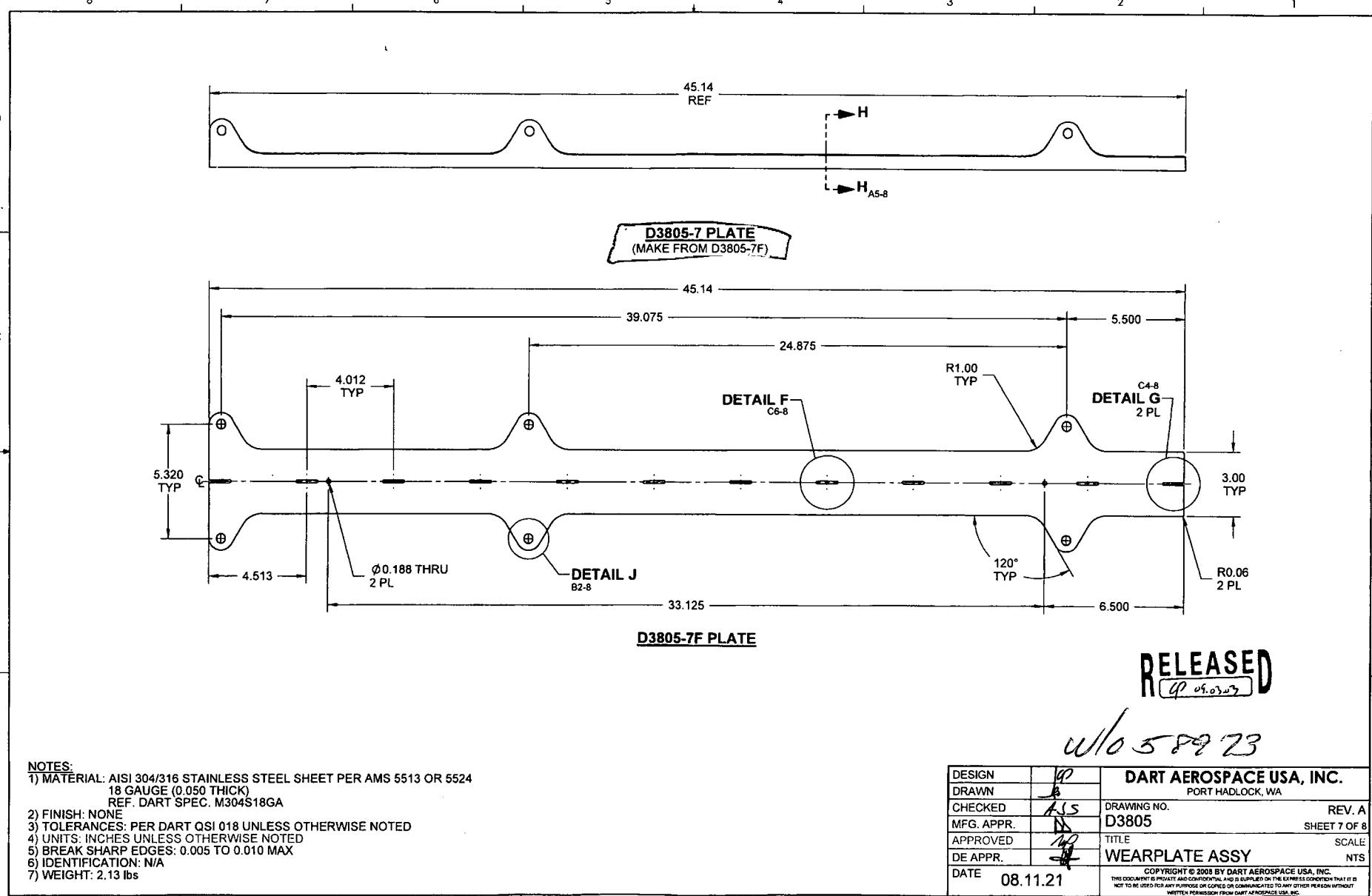


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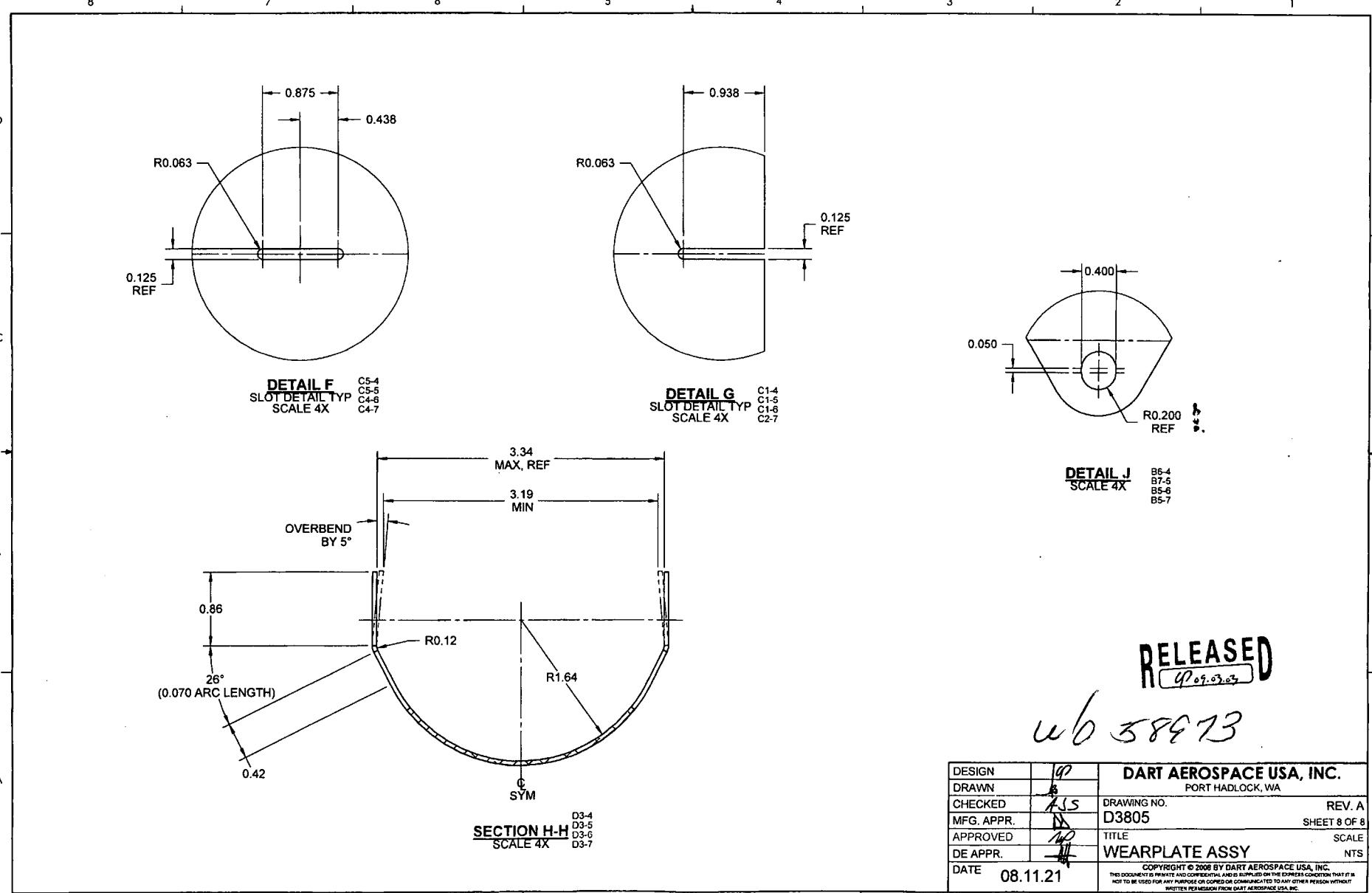


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